

Date: Thursday, 8/24/2006 11:11:44 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER BUSHING
Job Number	: 28334		
Estimate Number	: 10823		
P.O. Number	: N/A		
This Issue	: 8/24/2006	S.O. No.	: N/A
Prsh Rev.	: NC		
First Issue	: N/A	Type	: MACHINED PARTS
Previous Run	: 26742		
Written By	:		
Checked & Approved By	:		
Comment	: Est. D 05.14.02	Removed 303 SS	KJ/EC

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304R0375	304 SS ROUND BAR	
		Comment: Qty.: 0.1860 f(s)/Unit Total : 9.2978 f(s) M18993 (M304TR 0.375 W65) 3.348 ft Inventory Material: AISI 304 Round Bar Ø0.375" Batch: M100 255 → 5.952 ft	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL	
		Comment: HARDINGE CNC LATHE SMALL Turn per Folio FA232 and Dwg D2327 Deburr	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
5.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: ST31	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
06.08.26	2	Mat'l missing to complete w/o. 304ss tubing used instead M304 TR 0.375 w. .065 ID openend up to .257" sum. 250"		BC	06-08-26	18	GP 06.08.26 P~ QSI 042		

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector	
			Initial Design Mgr	Action Description Design Mgr	Sign & Date				
06-08-26	2								

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/09/01

NOTE: Date &amp; initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Thursday, 8/24/2006 11:11:44 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 28334

Part Number: D23271

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

 06/09/01

Job Completion



U86-09-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

DART AEROSPACE LTD	Work Order:	28334
Description: Spacer Bushing	Part Number:	D2327-1
Inspection Dwg: D2327 Rev: C		Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	06/08/25	Date:	06/08/25	Date:	N/A

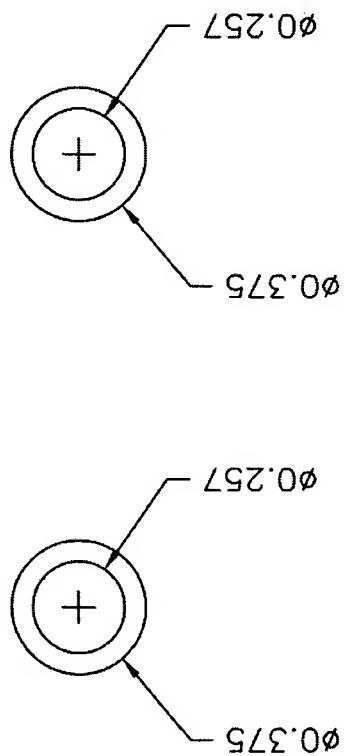
Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	TT

DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA	
DESIGN BY BW	DRAWN BY <i>JL</i>	DRAWING NO. D2327	REV. C SHEET 1 OF 1 SCALE 2:1
CHECKED <i>JL</i>	APPROVED <i>JL</i>		
DATE 03.05.13	TITLE SPACER BUSHING		
	A 94.12.17 NEW ISSUE		
	B 95.12.06 LENGTH CHANGE		
	C 03.05.13 303 SS SPEC ADDED		

OCT 1994  
DRAFT

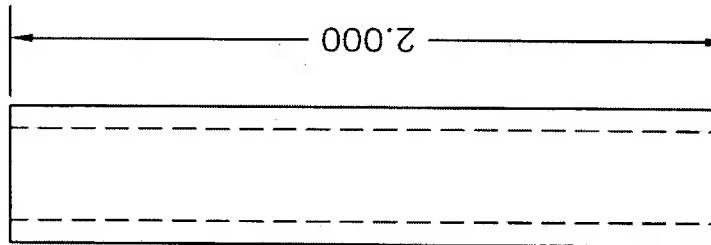
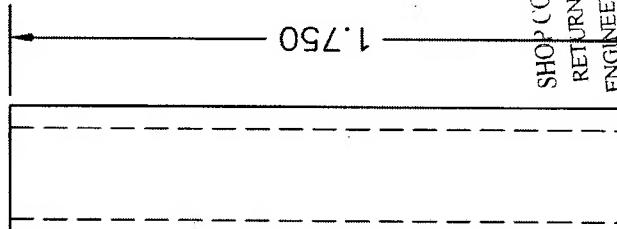
**DART**

**RELEASED**  
03.05.21 - *JL*



ALL DIMENSIONS ARE IN INCHES  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
FINISH: NONE  
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

MATERIAL: Ø0.375 AISI 303 ROUND BAR (REF DART SPEC.  
M303R0.375) OR Ø0.375 AISI 304/316 SS 0.065  
WALL SEAMLESS ROUND TUBING (REF. DART SPEC.  
M304TR0.375W.065)



NOTE:  
1) MATERIAL: Ø0.375 AISI 303 ROUND BAR (REF DART SPEC.  
M303R0.375) OR Ø0.375 AISI 304/316 SS 0.065  
WALL SEAMLESS ROUND TUBING (REF. DART SPEC.  
M304TR0.375W.065)  
2) FINISH: NONE  
3) BREAK ALL SHARP EDGES 0.005 TO 0.010  
4) ALL DIMENSIONS ARE IN INCHES  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) FINISH: NONE  
7) BREAK ALL SHARP EDGES 0.005 TO 0.010

NOTE:  
1) MATERIAL: Ø0.375 AISI 303 ROUND BAR (REF DART SPEC.  
M303R0.375) OR Ø0.375 AISI 304/316 SS 0.065  
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6) FINISH: NONE  
7) BREAK ALL SHARP EDGES 0.005 TO 0.010

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